Work Order ID 61880 - PRELIMINARY ISSUMMENT Wednesday, September 08, 2010 3:26:58 PM

Page 1

" curesuay, Se	premoer 00, 2010 51.									
Item ID:	D4173-3	. 1	1	Accept			s	etup Start		
Revision ID:	PRELIM	ple		,			TOTAL STORY	Stop		
Item Name:	Pod Radalt Doubler	2	•					Stop		
Start Date:	9/8/2010 Star	t Qty: 3.00			Cust Item ID:					
Required Date		'd Qty: 3.00			Customer:					
Reference:			,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,						11000000000	
Approvals:	Process Plan:	N	Date: 10-9-0	Tooling:	Date:		F	tun Star		
	QC:	/(Date:	SPC (Y/N):	Date:			Stop		
Sequence ID/ Work Center		ration cription		Set Up/ Run Hours	Tool ID To	ool# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision	Nbr	20							
D4173	PATA	42 M	10.08:18							
100	E			0.00						
							H31	0-9-13	-	
Waterjet		Memo		0.00					(4)	
FLOW CNC Water	erjet	1-Cut as pe	r Dwg	Par same	dim as Pal					
		Dwg Rev:_ Prog Rev:_	ONI	11						
			Y 1	Pa 2 same a 1/10.07	,16					
		2-Deburr if	necessary	**						
110	QC2	- Inspect parts off r	machine FAI/FAIB	0.00						
							OR 1	0-9-13		
QC		Memo		0.00			-			
Ouality Control										

Dart Ae	rospace	Ltd							,	9 4
W/O:			WC	RK ORDER CHAN	IGES				•	
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR	: Yes 1	No DQ	A:	Date:	
	Re	esolution:	Disposition	n:	QA:	N/C Clo	sed:		Date:	
NCR:			WORK ORDI	ER NON-CONFORM	MANCE	(NCR)			
		Description of NC		Corrective Action S	ection B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date		ion C	Chief Eng	QC Inspector

Wednesday, September 08, 2010 3:26:58 PM

Item ID:

D4173-3

Revision ID:

Required Date: 9/13/2010

PRELIM

Item Name:

Start Date:

9/8/2010

QC:

Pod Radalt Doubler

Start Oty: 3.00 Req'd Qty: 3.00



Accept



Setup Start



Start



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Date:

Date:

Stop

Run



Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

0.00 - inspector to PA)

130

HandFinish

Hand Finishing

Memo

0.00

140

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Chemical Conversion Coat per QSI005 4.1

M112588

Memo

Start Time: 2:43pm Oven Temperature: 320°(= Finish Time: 3.14520

0,00 =) SU 10/09/15

Dart Aerospace Ltd

W/O:			V	ORK ORDER CHANG	ES		,	
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Q	ty Approval Chief Eng / Prod Mgr	Approval QC Inspector
							Frouring	
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA:_	Date: _	
	Re	esolution:	Disposit	ion:	QA: N/C Clo	sed:	Date: _	
NCR:			WORK OR	DER NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC		Corrective Action Section		Verification	on Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector
			•					

Work Order ID 61880

Wednesday, September 08, 2010 3:26:58 PM



Page 3

Item ID:

D4173-3

Revision ID:

PRELIM

Item Name:

9/8/2010

QC:

Start Oty: 3.00

Accept



Setup

Start

Stop



Start Date:

Required Date: 9/13/2010

Pod Radalt Doubler

Req'd Qty: 3.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Tool#

Plan

Code

Run

Reject

Qty

Start Stop



Accept

Qty

Reject

Number

Insp.

Stamp

Sequence ID/

Work Center ID

150

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ Run Hours

0.00 - inspectes to Pal

Tan

Day orly Scolorlie (xco

160

Packaging

Packaging

Memo

0.00

0.00

35 10-09-23

170

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

0.00

Memo

0.00

L10.923

Quality Control

POSITIVE RECALL

Dart Ae	rospace L	td							
W/O:			WC	ORK ORDER CHANGI	ES				
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
NCR:				ER NON-CONFORMA					
		Description of NO		Corrective Action Section	on B	Vid			v A commission when y
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign a	& Sect	cation ion C	Approval Chief Eng	Approval QC Inspector

Picklist Print

Wednesday, September 08, 2010 3:27:07 PM

Work Order ID: 61880

D4173-3 Parent Item:

Parent Item Name: Pod Radalt Doubler



Start Date: 9/8/2010

Required Date: 9/13/2010

Page 1

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	104.9340	0.4935	1.558421			
										· ·	B10-9	-13	

6061-T6 .063 Sheet

Location Loc Qty Loc Code MAT21 104.934

> 113608 104.934

Dart Aeros	pace	_td
------------	------	-----

W/O:			V	ORK ORDER CHANGI	ES			(*)	
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Car	tegory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposit	ion:	QA: N/C CI	osed:		Date: _	
NCR:			WORK OR	DER NON-CONFORMA	NCE (NCF	1)			
DATE	STEP	Description of NC		Corrective Action Section	60/17/27/2		cation		Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector

· Route / Born/ Art DONE

> 7 224 1.300 7.024 1,300 3.512 PITCH 0.288 3.20 0.363 TYP TYP 180 0 0 1.378 R0,05 0 0 4 PL 4,620 7.38 5.63 0 0 2.310 PITCH 2,510 0 Ø 0.201 D4173-3 0.88 0 0 0 BXXXXX TYP 1100 0.063 R0.93 REF 0.88 4 PL 9.63

SHOP CORY RETURNING ENGINEERING UNCONTROLLED UPONY SUBJECT TO AMESTICAL . ? -WORK ORDER NO. 41880 PS10-9-09

> PRELIMINARY ISSUE 10.09.08

NOTES: 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC, M6061T6S,063 REF. DART SPEC, M6061T6S,063 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: PER QSI 044 6.1

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. PA1 D4173 MFG. APPR. SHEET 4 OF 4 TITLE APPROVED POD RADALT MOUNTING PLATE DE APPR COPYRIGHT © 2919 BY DART AEROSPACE LTD DATE 10.09.01

7) WEIGHT: 0.16 lbs

D4173-3 POD RADALT DOUBLER

D

DART AEROSPACE LTD	Work Order:	61880
Description: Pod RADALT Doubles	Part Number:	D4173-3
Inspection Dwg.D 4173-3 Rev: pA (Page 1 of 1

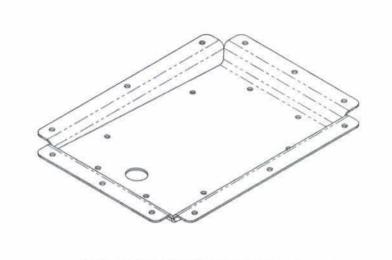
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
	1 11007 1101010	

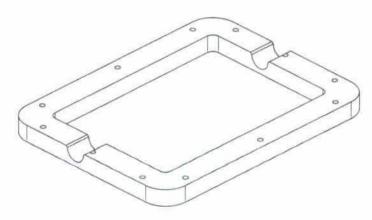
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
100,0	1005-001	205	79		V IBOZ	
. 288	4- 010	1294	7	*	V	
1.300	4- :010	1.304	>		V	
7.004	4 00	7.026	7		V	
3 512	400	3,517	B		V	
.363	4 ,016	.361	7		V	
1.378	-1-	1.378	8	-	V	
4.620	4 .010	4.618	8		117	
2.310	4 -010	3.308	7		V	
7.88	4030	7.873	7	-	-	
9.63		9,638	>	-	V	
,88	4 .030	.884	8	-	Y	
5,63	1.1	5.676	1	-		
7.38	+030	7,379	8	-	V	
,063	400	,060	Y	-	'	
		-	-		+	
				+		
			-			
			-			80
			1			
		-				

Measu	red by:	R	Audited by:	8	Prototype Approval:	N/A
medou	Date:	10-9-13	Date:	volac 13	Date:	N/A
				PAI Dy only	Revised by	Approved
Rev	Date	Change			KJ/JLM	

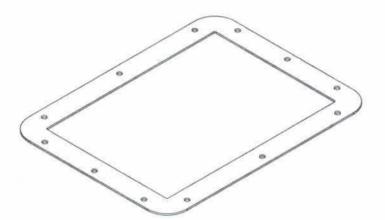
New Issue



D4173-041 POD RADALT MOUNTING PLATE ASSY



D4173-7 RADALT SCHIM



D4173-3 POD RADALT DOUBLER

61880

PRELIMINARY ISSUE

PA2	REVISED GE THICKNESS	OOVE IN	D4173-7; ADDED TOL ON D4173-7	MB	10.09.15		
PA1	NEW ISSUE			MB 10.09.0			
REV.			DESCRIPTION	BY	DATE		
DESIG	N	平	DART AEROSP	ACE L	TD		
DRAW	N	-4	HAWKESBURY, ONTAR	IO, CANAI	DA		
CHECK	KED		DRAWING NO.		REV. PAZ		
MFG.	APPR.		D4173		SHEET 1 OF 7		
APPRO	OVED		TITLE		SCALE		
DE AP	PR.		POD RADALT MOUNTING PLATE ASSY NT COPYNIGHT © 2019 BY DARY AERODAACE LTD COPYNIGHT © 2019 BY DARY AERODAACE LTD COPYNIGHT © 2019 BY DARY AERODAACE LTD COPYNIGHT OF COPYNIGHT				
DATE	10.09.0)1					

7.024 1.300 3.512 PITCH D 0.313 0.363 TYP TYP \oplus 0 0 1.378 R0.05 0 0 4 PL 4.620 0 0 7.38 5.63 2.310 PITCH C 0 0 Ø0.201 D4173-3 0.88 0 0 0 BXXXXX TYP 0.063 REF R0.93 0.88 4 PL 9.63 **D4173-3 POD RADALT DOUBLER** PRELIMINARY ISSUE 10.09.15 NOTES: 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM 8209 REF. DART SPEC, M6061T6S.063 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA NEP. DART SPEC, M808T16S,063

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1 DRAWING NO. CHECKED REV. PA2 D4173 MFG, APPR. SHEET 5 OF 7 TITLE APPROVED SCALE POD RADALT MOUNTING PLATE ASSY NTS DE APPR. COPYRIGHT IS 2910 BY DART AEROSPACE LTD DATE 10.09.01 7) WEIGHT: 0.16 lbs 2 7

7.024 1,300 3.512 PITCH D 0.313 --9.000 - 0.363 0 0 R0.05 0 0 4.620 7.38 5.63 0 0 6.650 2.310 PITCH 0 0 D4173-3 BXXXXX Ø0.201 0.88 0 TYP 0.063 R0.93 REF 0.88 4 PL 9.63 **D4173-3 POD RADALT DOUBLER** NOTES: 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063 DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED CHECKED DRAWING NO. REV. A D4173 MFG. APPR. SHEET 5 OF 8 APPROVED TITLE 4) UNITS: INCHES UNLESS OTHERWISE NOTED POD RADALT MOUNTING PLATE ASSYNTS 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX DE APPR. 6) IDENTIFICATION: PER QSI 044 6.1 DATE COPYRIGHT & 2010 BY DART AEROSPACE LTD 10.09.01 7) WEIGHT: 0.16 lbs 7